

Date: Monday, 25/08/2008 9:56:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 41613	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 25/08/2008 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41602	Material :
Written By :	Due Date : 30/09/2008 Qty: 16 Um: Each
Checked & Approved By : <u>JLD 08.8.25</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
 6061-T6 7.0x6.5x2.0
 350 Saddle Billet
 Batch: B41962

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. SA Double check by: SL

- 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
- 4-Deburr
- 5-Tumble to remove sharp edges.

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/08/2008 9:56:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 41613

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten signature

08-10-23

(X16)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109152

START TIME:

10:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:45am

Handwritten signature

08-10-23

(X16)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Handwritten signature

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten signature

9.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

08/10/24

Job Completion



mf 08-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41613
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.499	.499	.499	.499		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.500	6.500	6.500	6.500		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.112	.112	.112	.112		
AA	R1.125	R1.145		1.130	1.130	1.130	1.130		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.260	.260	.260	.260		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.156	.150		
Accept/Reject									

Measured by:	J.S.
Date:	08/10/19

Audited by:	ML
Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	41613
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.112	.112	.112	.112		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.260	.260	.260	.260		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:	JB
Date:	08/10/20

Audited by:	Inf
Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	Inf

DART AEROSPACE LTD		Work Order:	41613
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.483	0.490		.484	.484	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.112	.112	.112	.112		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.628	.628	.628	.628		
AD	0.240	0.260		.250	.260	.260	.260		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.260	.260		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:	JB
Date:	08/10/20

Audited by:	ML
Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	JB

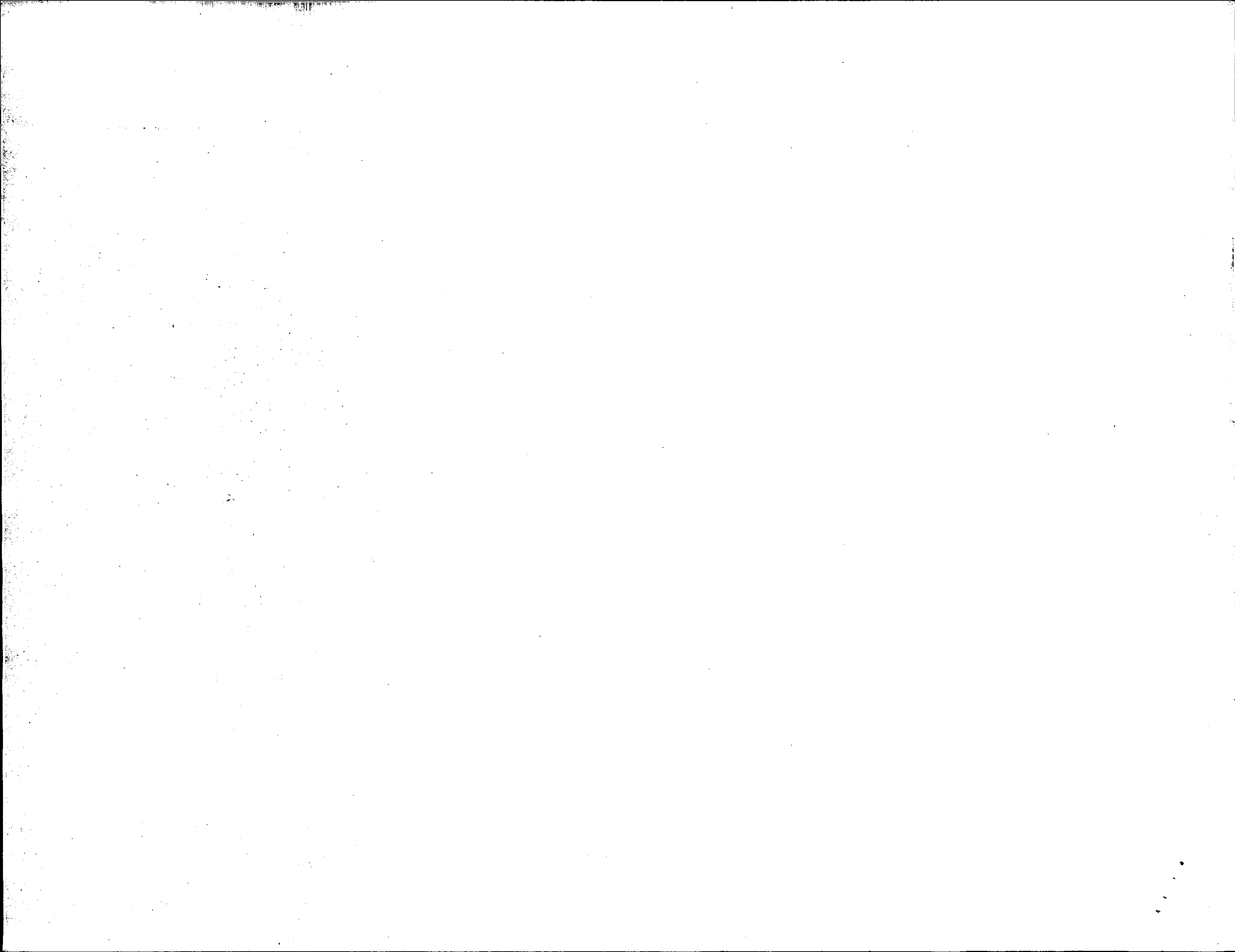
DART AEROSPACE LTD		Work Order: 41113
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

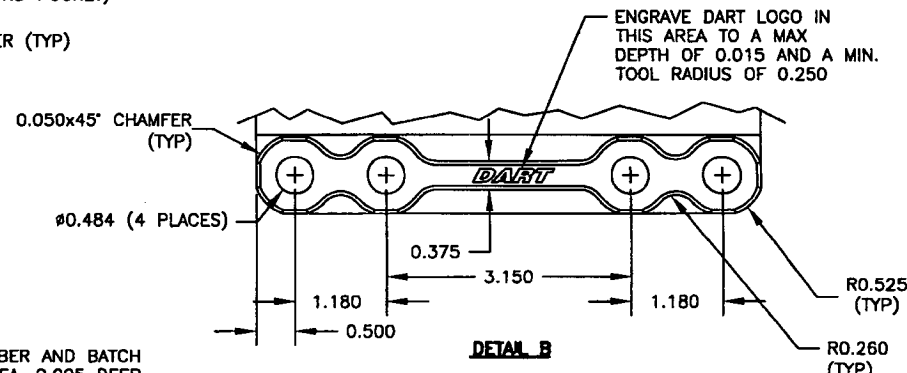
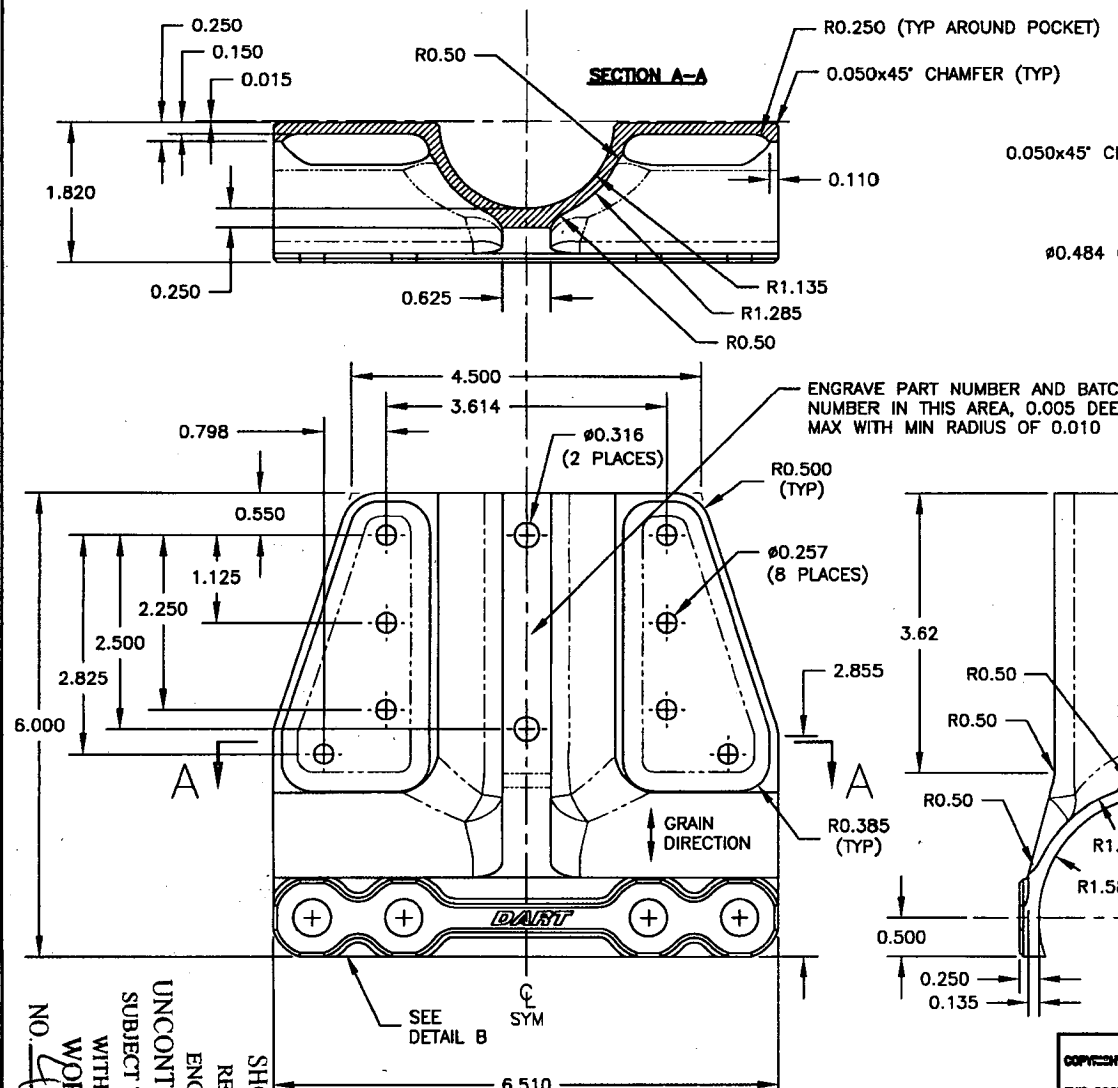
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	13	14	15	16		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:	JS
Date:	08/10/20

Audited by:	Con
Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	JS





D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C SHEET 1 OF 1
DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA		SCALE 2:3

NO. 41613
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WITHOUT NOTICE
WORK ORDER

